

Date: Tuesday, 11/29/2005 3:06:17 PM  
 User: Linda Lacelle

## Process Sheet

|                                  |  |                         |  |
|----------------------------------|--|-------------------------|--|
| <b>Customer</b>                  | : CU-DAR001 Dart Helicopters Services                                    | <b>Drawing Name</b>     | : SADDLE FITTING, AFT (OUTBOARD/INBOARD) |
| <b>Job Number</b>                | : 25019  |                         |  |
| <b>Estimate Number</b>           | : 10534  |                         |  |
| <b>P.O. Number</b>               | : N/A  | <b>Part Number</b>      | : D2574                                  |
| <b>This Issue</b>                | : 11/29/2005   | <b>Drawing Number</b>   | : D2574 REV D                            |
| <b>Prsht Rev.</b>                | : NC   | <b>Project Number</b>   | : N/A                                    |
| <b>First Issue</b>               | : N/A  | <b>Drawing Revision</b> | : D                                      |
| <b>Previous Run</b>              | : 24840  | <b>Material</b>         | : N/A                                    |
| <b>Written By</b>                | : SEE COMMENT BELOW  | <b>Due Date</b>         | : 1/5/2006                               |
| <b>Checked &amp; Approved By</b> | : SEE ABOVE DATE & USEC.   | <b>Qty:</b>             | 8  |
| <b>Comment</b>                   | : Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ |                         |  |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |          |                         |
|-----|----------|-------------------------|
| 1.0 | D6101005 | 7075-T7351 8.25X5.0X2.5 |
|-----|----------|-------------------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 7075-T7351 8.25X5.0X2.5  
 Make from D6101-005 billet for D2574  
 Ensure that grain is along 5.00" length  
 Batch No: B21817A (1) B25204 J.G. 06/01/16 8

|     |       |                                |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. 25019 Double check by: SD J.G. 06/01/16  
 MS 06/01/18  
 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove sharp edges. N/A

|     |               |                              |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2573 & D2574 -MS 06/01/18  
 -J.G. 8

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RD Date: 06/02/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 3:06:17 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25019

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



-MS 06/01/18  
-J.G.



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

86

06-01-24

8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-02-09

8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/02/19

8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C206102120

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51480

C206102120

(8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/21

(8)

DD 06/02/21

(8)

Job Completion



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

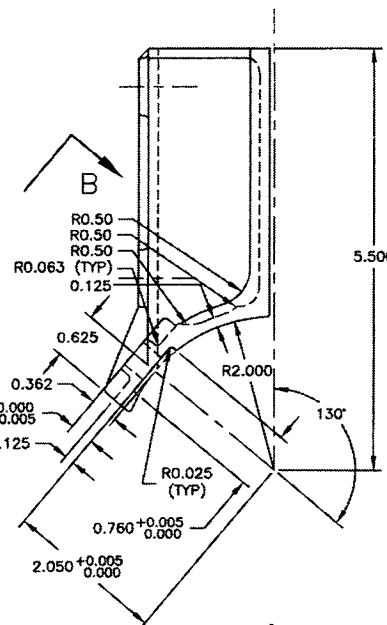
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

02-07-25









SECTION A-A

Technical drawing of a mechanical part, SECTION A-A, showing a cross-section of a curved component. The drawing includes the following dimensions and features:

- Overall width:  $3.230 \pm 0.020$
- Top left radius:  $R0.50$  (TYP)
- Top center radius:  $R1.510$
- Top right radius:  $R0.50$  (TYP)
- Bottom left radius:  $R0.188$  (TYP AROUND POCKET)
- Bottom center radius:  $R0.50$  (TYP)
- Bottom right radius:  $R0.50$  (TYP)
- Top center flat:  $0.250$  (TYP ALL RIDGES)
- Top right flat:  $0.240$  FLAT ON RIDGE
- Top right radius:  $0.250$
- Bottom center radius:  $0.125$
- Bottom right radius:  $0.125$
- Bottom right flat:  $0.250$
- Overall height:  $1.698$  (REF)
- Bottom left radius:  $0.063$
- Bottom center radius:  $0.125$
- Bottom right radius:  $0.250$

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND

|  |  |  |   |
|--|--|--|---|
| D  | 02.09.06   | ADD RIDGES; TIGHTEN TOLERANCES                             |  |
| C  | 99.10.22   | INCORP. DEO 9123/9079/9102<br>ADD DIMENSIONS PER TSR A1177 |   |
| B  | 96.12.02   | ADD GRAIN DIR., 0.438 WAS 0.425                            |   |
| A  | 96.09.16   | NEW ISSUE  |   |
| DESIGN  DRAWN BY  <div style="display: inline-block; text-align: center;">  <b>DART AEROSPACE LTD.</b><br/> <small>HARRISBURG, ONTARIO, CANADA</small> </div> |  |  |   |
| CHECKED   | APPROVED  | DRAWING NO.<br>D2574                                       | REV. _____<br>SHEET 1 OF _____  |
| DATE<br>02.09.06   |  | TITLE<br>INNER AFT SADDLE                                  |   |

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DART AEROSPACE LTD.

**DART AEROSPACE LTD.**  
 MISSISSAUGA, ONTARIO, CANADA

RE  
SHEET 1

|       |                  |
|-------|------------------|
| TITLE | INNER AFT SADDLE |
|-------|------------------|

REV. 1  
T 1 OF  
SCALE  
2

|   |  |                           |
|---|--|---------------------------|
| <b>DART AEROSPACE LTD</b>               |  | <b>Work Order:</b> 25019  |
| <b>Description:</b> Saddle, Aft Inboard |  | <b>Part Number:</b> D2574 |
| <b>Inspection Dwg:</b> D2574 Rev. E     |  | Page 1 of 1               |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3     | 4     | By | Date |
| A             | 0.438 | 0.443 | DT8682         | ✓                          | ✓     | ✓     | ✓     |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.747 |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.497 |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.748 |    |      |
| E             | 7.990 | 8.010 |                | 8.002                      | 8.003 | 8.004 | 8.004 |    |      |
| F             | 0.490 | 0.510 |                | .505                       | .503  | .506  | 0.500 |    |      |
| G             | 0.257 | 0.262 | DT8683         | ✓                          | ✓     | ✓     | ✓     |    |      |
| H             | 0.375 | 0.380 | DT8684         | ✓                          | ✓     | ✓     | ✓     |    |      |
| I             | 0.490 | 0.510 |                | .502                       | .504  | .505  | 0.499 |    |      |
| J             | 1.174 | 1.184 |                | 1.180                      | 1.180 | 1.180 | 1.179 |    |      |
| K             | 0.558 | 0.578 |                | .571                       | .574  | .574  | 0.569 |    |      |
| L             | 1.174 | 1.184 |                | 1.180                      | 1.180 | 1.180 | 1.179 |    |      |
| M             | 1.365 | 1.375 |                | 1.370                      | 1.370 | 1.369 | 1.370 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.497 |    |      |
| O             | 4.119 | 4.129 |                | 4.121                      | 4.124 | 4.124 | 4.120 |    |      |
| P             | 0.115 | 0.135 |                | .126                       | .125  | .127  | 0.128 |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | .135  | .135  | 0.135 |    |      |
| R             | 0.240 | 0.260 |                | .250                       | .250  | .250  | 0.251 |    |      |
| S             | 0.115 | 0.135 |                | .126                       | .125  | .125  | 0.126 |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| U             | 3.210 | 3.250 |                | 3.232                      | 3.234 | 3.232 | 3.231 |    |      |
| V             | 0.230 | 0.250 |                | .243                       | .241  | .240  | 0.241 |    |      |
| W             | 0.115 | 0.135 |                | .125                       | .125  | .125  | 0.125 |    |      |
| X             | 0.307 | 0.312 |                | .308                       | .311  | .311  | .309  |    |      |
| Y             | 0.760 | 0.765 |                | .762                       | .762  | .762  | .762  |    |      |
| Z             | 0.352 | 0.372 |                | .365                       | .360  | .362  | 0.365 |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  | .500  | .500  |    |      |
| AB            | 0.615 | 0.635 |                | .626                       | .629  | .629  | 0.623 |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  | .063  | .063  |    |      |
| AD            | 0.240 | 0.260 |                | .250                       | .248  | .246  | 0.247 |    |      |
| AE            | 1.500 | 1.520 |                | 1.511                      | 1.511 | 1.511 | 1.511 |    |      |
| AF            | 0.115 | 0.135 |                | .135                       | .135  | .135  | 0.135 |    |      |
| AG            | 0.240 | 0.280 |                | .272                       | .270  | .270  | 0.271 |    |      |
| AH            | 0.240 | 0.260 |                | .252                       | .248  | .250  | 0.249 |    |      |
| AI            | 2.000 | 2.020 |                | N/A                        | N/A   | N/A   | N/A   |    |      |
| AJ            | 0.023 | 0.043 |                | .03                        | .03   | .03   | .03   |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |          |
|--------------|----------|
| Measured by: | MS       |
| Date:        | 06/01/18 |

|             |          |
|-------------|----------|
| Audited by: | J.G      |
| Date:       | 06/01/18 |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.27 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |

RELEASED  
05.12.05

|   |                           |
|---|---------------------------|
| <b>DART AEROSPACE LTD</b>               | <b>Work Order:</b> 25019  |
| <b>Description:</b> Saddle, Aft Inboard | <b>Part Number:</b> D2574 |
| <b>Inspection Dwg:</b> D2574 Rev. E     | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3     | 4     | By | Date |
| A             | 0.438 | 0.443 | DT8682         | 0.441                      | ✓     | ✓     | ✓     |    |      |
| B             | 1.745 | 1.755 |                | 1.748                      | 1.750 | 1.750 | 1.750 |    |      |
| C             | 3.495 | 3.505 |                | 3.497                      | 3.501 | 3.500 | 3.500 |    |      |
| D             | 1.745 | 1.755 |                | 1.747                      | 1.750 | 1.750 | 1.750 |    |      |
| E             | 7.990 | 8.010 |                | 8.004                      | 8.003 | 8.004 | 8.003 |    |      |
| F             | 0.490 | 0.510 |                | 0.500                      | .499  | .499  | .502  |    |      |
| G             | 0.257 | 0.262 | DT8683         | 0.260                      | ✓     | ✓     | ✓     |    |      |
| H             | 0.375 | 0.380 | DT8684         | 0.377                      | ✓     | ✓     | ✓     |    |      |
| I             | 0.490 | 0.510 |                | 0.4985                     | .501  | .501  | .500  |    |      |
| J             | 1.174 | 1.184 |                | 1.178                      | 1.180 | 1.180 | 1.180 |    |      |
| K             | 0.558 | 0.578 |                | 0.570                      | .568  | .572  | .575  |    |      |
| L             | 1.174 | 1.184 |                | 1.176                      | 1.180 | 1.180 | 1.180 |    |      |
| M             | 1.365 | 1.375 |                | 1.360                      | 1.370 | 1.370 | 1.370 |    |      |
| N             | 2.495 | 2.505 |                | 2.497                      | 2.501 | 2.500 | 2.500 |    |      |
| O             | 4.119 | 4.129 |                | 4.119                      | 4.121 | 4.122 | 4.123 |    |      |
| P             | 0.115 | 0.135 |                | 0.128                      | .125  | .125  | .126  |    |      |
| Q             | 0.115 | 0.135 |                | 0.134                      | .135  | .135  | .135  |    |      |
| R             | 0.240 | 0.260 |                | 0.250                      | .247  | .250  | .250  |    |      |
| S             | 0.115 | 0.135 |                | 0.124                      | .125  | .123  | .123  |    |      |
| T             | 0.178 | 0.198 |                | 0.188                      | .188  | .188  | .188  |    |      |
| U             | 3.210 | 3.250 |                | 3.230                      | 3.231 | 3.231 | 3.231 |    |      |
| V             | 0.230 | 0.250 |                | 0.234                      | .240  | .240  | .240  |    |      |
| W             | 0.115 | 0.135 |                | 0.122                      | .125  | .125  | .125  |    |      |
| X             | 0.307 | 0.312 |                | 0.312                      | .310  | .310  | .310  |    |      |
| Y             | 0.760 | 0.765 |                | 0.760                      | .762  | .762  | .762  |    |      |
| Z             | 0.352 | 0.372 |                | 0.356                      | .356  | .359  | .356  |    |      |
| AA            | 0.470 | 0.530 |                | 0.500                      | .500  | .500  | .500  |    |      |
| AB            | 0.615 | 0.635 |                | 0.622                      | .626  | .623  | .627  |    |      |
| AC            | 0.053 | 0.073 |                | 0.063                      | .063  | .063  | .063  |    |      |
| AD            | 0.240 | 0.260 |                | 0.246                      | .248  | .246  | .247  |    |      |
| AE            | 1.500 | 1.520 |                | 1.510                      | 1.511 | 1.511 | 1.511 |    |      |
| AF            | 0.115 | 0.135 |                | 0.130                      | .135  | .135  | .135  |    |      |
| AG            | 0.240 | 0.280 |                | 0.265                      | .269  | .270  | .270  |    |      |
| AH            | 0.240 | 0.260 |                | 0.246                      | .251  | .251  | .251  |    |      |
| AI            | 2.000 | 2.020 |                | N/A                        | N/A   | N/A   | N/A   |    |      |
| AJ            | 0.023 | 0.043 |                | 0.033                      | .03   | .03   | .03   |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |          |
|--------------|----------|
| Measured by: | /ms      |
| Date:        | 06/01/21 |

|             |          |
|-------------|----------|
| Audited by: | J.G.     |
| Date:       | 06/01/21 |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.27 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |